

Title (en)  
TUBES AND THEIR MANUFACTURE

Title (de)  
RÖHREN UND DEREN HERSTELLUNG

Title (fr)  
TUBES ET LEUR FABRICATION

Publication  
**EP 2224985 B1 20120801 (EN)**

Application  
**EP 08870172 A 20081211**

Priority  
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Abstract (en)  
[origin: WO2009087347A1] An end fitting (31) is formed at the patient end of an inner cannula (3) for a tracheostomy tube (1) by punching small holes (33) close to one end (34) of an ePTFE shaft (30). The end is then swaged to form an expanded region (30') and a preformed tubular insert (40) of a thermoplastic material is inserted to cover the holes (33) on the inside. An outer part (46) of the same thermoplastic material is then overmoulded on the outside of the shaft 30 so that its material (47) flows through the holes (33) and bonds with the inner insert (40), thereby securing the inner and outer parts together around the end of the shaft.

IPC 8 full level  
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CPC (source: EP US)  
**A61M 16/0427** (2014.02 - EP US); **A61M 16/0465** (2013.01 - EP US)

Cited by  
WO2014132016A1; WO2015166200A1; WO2017037404A1; WO2014132015A1; WO2017009592A1; WO2015136232A1; WO2016166498A1; WO2016198818A1; WO2016198817A1

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